Page 1

| Revision 1D: | D350-748-10 U/R Crosstube Inst | 01 tallation, High Fwd | | Accept | *N900 |)040 | 100 |) * ፡ | Setup Star | I VI | S1* |
|---|--------------------------------------|---|--------------------------------|---|------------------------|--------|--------------|---------------|------------------|------------------|----------------|
| Start Date: Required Date: Reference: | 21/1·2/2011 13/01/2012 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item Customer: | | | | | I | .7/ |
| Approvals: | | in: M.C.J | | | | Pate: | | F | Run Star Stop | 171 | R1* |
| Sequence ID/ Work Center ID |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr D350-748-141 | | ision Nbr /R | | | | * | | | | | |
| *100 *100* DC Document Control | | DOCUMENT CONTRO Memo Photocopy b | L luefile & type labels(per | 0.00 0.00 PPPD350-7485101 | CHG002 | | | | 1 | | |
| *110 *11 | der | BENDING MACHINE - Memo Bend tube as Folio FT | | 0.00 0.00 1 using CNC bender progra | ım D350F and | D | | 12 | 2-1 | <u>'-18</u> | |
| *120 *120*. QC Quality Control | ÷ | QC15- Crosstube Dimens | sional Check | 0.00 | | · | | | | • | |

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| W/O: | | , <u>, , , , , , , , , , , , , , , , , , </u> | WO | RK ORDER CHANC | GES | | | - | 1.50-7-7-7-2-1 | |
| DATE | STEP | PRO | CEDURE CHAN | IGE | | Ву | Date C | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Categ | jory: | NCF | R: Yes N | lo DQA: _ | | Date: | |
| Resolution: | | | _ Disposition | : | QA: | N/C Clo | sed: | | _ Date: | • |
| NCR: | | | ORK ORDE | R NON-CONFORM | ANCE | (NCR) | | | | |
| | | Description of NC | Corrective Action Section B | | | Veriti | | cation Approval | Annroval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | | | Sign & Date | Section C | | Chief Eng | QC Inspector |
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| Work Ord December-21-1 | | | | *777 | 769* | | | | | | | Page 2 |
|---|-------------------|---------------------------------------|--|----------------------|--------------------------|--------|--------------|--------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: | D350-748-1 U/R | 01 | | Accept | *N900 | 040 | 1100 |)* | Setup | Start | *N. | S1* |
| Item Name: Start Date: Required Date: Reference: | 21/12/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | | Stop | *N: | S2* |
| Approvals: | Process Pla | nn: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | " | R1* R2* |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| *125* HandFXtube Hand Finishing Cro | sstubes | Temp: Start time: | osstube as per QSI010 4.3 375 4h30 | 0.00 | | | | 1 | | _ | 301 | D_12-01- |
| 127 | | Finish time: QC6- Inspect dimensions | · | 0.00 | | | | | | | | |

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Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | | | |
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| Part No: _ | | PAR #: | Fault Category: | NCR: Yes No DQA: | Date: |
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| • | Resolution: | | Disposition: | QA: N/C Closed: | _ Date: |

| NCR: | 7,7,7 | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | | | |
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| · · · · · · | | Description of NC | | Corrective Action Section B | Verification | Approval | A | | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | Approval QC Inspector | | | | | |
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| | Work Order ID 77769 December-21-11 9:29:23 AM | | | *777 | 769* | | | | | *************************************** | Page 3 |
|--------------------------------|---|--|--|------------------------------|-------------------------------|-------|--------------|---------------|--------------------|---|----------------|
| Revision ID: Item Name: | | ition, High Fwd start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | Accept | *N900 Cust Item I Customer: | | 100 |)* | Setup Star Stop | I VI | S1* S2* |
| Approvals: | Process Plan: QC: | | Date: | Tooling: SPC (Y/N): | | ate: | - | 1 | Run Star Stop | "1/ | R1* R2* |
| Sequence ID/ Work Center II |) De | peration escription | | Set Up/ Run Hours 0.00 | Tool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| *130* Crosstubes | | Memo 1-Drill Tube : Set-up dril 2-Deburr { 3-Engrave Pa 4-Remove all | table as per QSI 010 rt # and Batch # as per I | limits of D350-748-141 | E Drill Jigs, | 10/ s | 12, | | 12/1/ | 23 | |

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QC5- Inspect part completeness to step on W/O

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Quality Control

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| W/O: | | | WORK ORDER CHANGES | | | | | | | | | | | | |
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| Part No | · | PAR #: | Fault Cate | egory: | _ NCR: Yes N | lo DQA: | Date: _ | 11 | | | | | | | |
| | R | esolution: | Disposition | on: | QA: N/C Clo | sed: | Date: _ | | | | | | | | |
| NCR: | | V | WORK ORE | ER NON-CONFORM | ANCE (NCR) | | | | | | | | | | |
| DATE | OTED | Description of NC Corrective Action Section | | | | Verification | | Approval | | | | | | | |
| DATE | STEP | Section A | Initial Action Description Chief Eng Chief Eng | | Sign & Date | Section C | Chief Eng | QC Inspector | | | | | | | |
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Work Order ID 77769 *77769* Page 4 December-21-11 9:29:23 AM Item ID: D350-748-101 Accept *N900040100* Setup Start **Revision 1D:** U/R **Item Name:** Crosstube Installation, High Fwd **Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID: Required Date:** 13/01/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: **Approvals:** Date: **Tooling:** Date: SPC (Y/N): Date: Date: Sequence ID/ **Operation Tool ID** Tool # Plan Set Up/ Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number **Qty** Stamp 150 Outsource process-Cadplate per OSI017 4.1.9.1 0.00 *150* CL 12/0/(25 D Outsource3 0.00 Memo Outsource process - Cad plate Issue P/O: Stress relief at 375° for 5 hours Magnetic Particle Inspect per ASTM E1444 Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375° for 8 hours, Chromate Treat Possibe Supplier: Southwest United Industries Ensure Certificate of Conformity is attached 160 Receive & Inspect for Damage & Mat'l Certs 0.00 *160* Packaging 0.00 Memo Packaging Ensure certificate of conformity is attached 170 QC5- Inspect part completeness to step on W/O 0.00 *170*

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| W/O: | | 77796 | WORK ORDER CH | HANGES | | | | |
|------|------|-------|------------------|--------|------|-----|-------------------------------------|------------------------|
| DATE | STEP | | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspecto |
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| Part No: <u>DSX- 746-131</u> | PAR #: | + Des an | NCH: Yes No | DQA: | -Date: ///05//6 |
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| Resolution: _ | SCrAN | Disposition: SCAP | QA: N/C Closed | 1: _ <i>CK</i> | Date: 12/3/16 |

| NCR: | ` | • | WORK OR | DER NON-CONFORMANC | CE (NCR) | zsus, | | |
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| DATE | 0.750 | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief∕Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
| | | takes broke while at | | SCrAD + Desty. | Wo | Th | asp | |
| -1-10 | 244 | CAD Platfor. | 12/63/12 | SCRAD+ DOSMY. | 12/3/13 | 12-3-13 | 1 . / | |
| 2/3/12 | 15D | R.(, Dows. | p5542 | | | 12-3-15 | PSJ042 | |
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| Work Order 1 | ID 77769 |
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| December-21-11 9: | 29:23 AM |

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Page 5

| Item ID: | D350-748-10 | 01 | | Accept | *N900 | 040 | 110 | ገ* ያ | Setup Sta | rt *N I | C1* |
|--------------------------------|-------------|---------------------------|--|---------------------------------|------------------|---|--------------|---------------|---------------|------------------|----------------|
| Revision ID: | U/R | 4-11-41- XX X D - 1 | | | | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, | | | Sto | | . 7 1 |
| Item Name: | | tallation, High Fwd | | | | | | | Sto | P *N | S2* |
| Start Date: | 21/12/2011 | Start Qty: 1.00 | *1 | * | Cust Item | ID: | | | | | |
| Required Date: | 13/01/2012 | Req'd Qty: 1.00 | *1 | * | Customer: | | | | | | |
| Reference: | | | _ | | | | | | | | |
| Approvals: | Process Pla | in: | Date: | Tooling: | D | ate: | | F | Run Sta | 1/1 | R1* |
| | QC: | | Date: | SPC (Y/N): | D | ate: | | | Sto | *N | R2* |
| Sequence ID/ Work Center II |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| 180 | | | • | 0.00 | | | | | - • | | - |
| *1ጸበ* | | SprayPaint | | | | | | | | | |
| SprayPaint | | Memo | | 0.00 | | | | | | | |
| Spray Painting | | 1-Prime ins 2-Prime Ou | ide crosstube as per (tside of Tube as per l | QSI 005 4.2 Dart QSI 005 4.2 | | | | | | | |
| 190 | | QC14- Inspect Spray Pa | int | 0.00 | | | | | | | |
| *190* | | QC14 mapeet apray 1 a | me | 0.00 | | | | | | | |
| QC | | Memo | | 0.00 | | | | | | | |
| Quality Control | | | in plastic bag to prot | | | | | | | | |
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| 200 | | | | 0.00 | | | | | | | |
| *200* | | Crosstubes | | | | | | | | | |
| Crosstubes | | Memo | | 0.00 | | | | | | | |
| Crosstubes | | 1-Install Gro | ound wire Insert,then | insert screw and washer | | | | | | | |
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2-Install Abraision strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 INLBS

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| W/O: | | | V | VORK ORDER CHANGE | ES | | _ | ***** | ę. . |
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| Part No | | PAR #: | Fault Ca | tegory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| | R | esolution: | Disposit | ion: | QA: N/C C | losed: | | Date: _ | |
| NCR: | | • | WORK OR | DER NON-CONFORMA | NCE (NC | ₹) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | | cation | Approval | Approval |
| | 0.2. | Section A | initial Chief Eng | Action Description Chief Eng | Sign Date | | ion C | Chief Eng | QC Inspector |
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| Work Orde | | | | *777 | 769* | | | | | | | Page |
|---|------------------------------------|--|------------------------|----------------------|-----------------------|--------|--------------|---------------|------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D350-748-1 U/R Crosstube Ins | 01 stallation, High Fwd | | Accept | *N900 | 040 | 1100 |)* | Setup | Start Stop | 1 1 | S1* S2* |
| Start Date: Required Date: Reference: | 21/12/2011 13/01/2012 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item 1 Customer: | ID: | | | | | I | .7/ |
| Approvals: | Process Plan:QC: | | Date: | Tooling: | D | ate: | | | Run | Start | *N | R1* |
| | | | Date: | SPC (Y/N): | | ate: | | | | Stop | | R2* |
| Sequence ID/ Work Center II |) | Operation Description QC5-Inspect part compl | eteness to step on W/O | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| *210* QC Quality Control | | Мето | | 0.00 | | | | | | | | |
| 220 | | Pick Kit | | 0.00 | | | | | | | | |
| *220* Packaging Packaging | | Memo | | 0.00 | | | | | | | | |

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Quality Control

QC4- 100% Inspect kits for completeness

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| W/O: | | | W | ORK ORDER CHANG | ES | | | | 1 |
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| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | D | ate Qty | Approval Chief Eng / | Approval QC Inspector |
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| | | Description of NC | | Corrective Action Secti | | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sig Da | n & | Section C | Chief Eng | QC Inspector |
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| Work Ord December-21-1 | | | | *777 | 769* | | | | | | | Page ' |
|---|------------------------------------|---------------------------------------|--------------------|----------------------|-------------|--------|--------------|--------------|---------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D350-748-1 U/R Crosstube Ins | 01 tallation, High Fwd | | Accept | *N900 | 040 | 100 |)* | Setup | Start Stop | 1.71 | S1* S2* |
| Start Date: Required Date: Reference: | 21/12/2011 13/01/2012 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item : | | | | | | | |
| Approvals: | Process Pla | ın: | Date: | Tooling: | D | ate: | _ | | Run | Start | *N | R1* |
| | QC: | | Date: | SPC (Y/N): | | ate: | | | | Stop | *N | R2* |
| Sequence ID/ Work Center II 240 |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accep Qty | t Reje Qty | | Reject Number | Insp. Stamp |
| * 740 * Packaging | | Packaging Memo | | 0.00 | | | | | | | | |
| Packaging | | Identify and Location: PPP Rev: | | PPP D350-748-101 | | | | | | | | |
| 250 | | QC21- Final Inspection - | Work Order Release | 0.00 | | | | | | | | |

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Quality Control

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| EFFECTIVE 12-01-13 | AUTH/ |
| RELEASED | DATE |

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| NCR: | | W | ORK ORE | DER NON-CONFORMA | NCE (N | CR) | | | | |
| DATE | OTED | Description of NC | | Corrective Action Section | | | Verificati | ion | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | n & ate | Section (| | Chief Eng | QC Inspector |
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Picklist Print

December-21-11 9:29:28 AM

Work Order ID: 77769

77769

Parent Item:

D350-748-101

D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 06-07-05 JLM

IPP Rev:B Update qty of MS21042L5 06-09-12 KJ

IPP Rev:C Rev B 07-11-15 DD

IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F

10.08.04 added QSI010 4.3 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D350-748-141TRN | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| *D350-748 Crosstube Turning Detail | R-141TF | SN* | | | | | 3745 | 585 | ** | SA | 0 | 12-0 | 1-1 |
| ALS4-1032-225 | | Purchased | No | | | 200 | Each | 1,348.000 |) 1 | 1 | | | |
| *AI \$4-10: | 32-225* | | | | | | | | ** | | | | |
| | | | | Location | | Loc (| Otv | Loc Code | | | | | |

| Insert | | | | | | | | | |
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| | | | | Location | Ī | oc Oty | Loc Code | | |
| | | | | ST281 | | 1348 | | | |
| | | | | 108696 | | 199 | | | |
| | | | | 110768 | | 62 | | | |
| | | | | 118386 | | 858 | | | |
| 1310 (0.15) | | | | 118966 | | 229 | | | |
| AN960JD10 | NAS1149D0363J | Purchased | No | | 200 | Each | 0.0000 | 1 | 1 |
| *AN960.ID | 10* | | | | | | | ** | |
| D2856-400 | | Manufactured | No | | 200 | f | 200.2721 | 1.181 | 1.243158 |
| *D2856-40 |) 0* | | | | | | | ** | 1.243138 |

Abraison Strip

| Location | Loc Oty | Loc Code | |
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| ST409 | 200.2721 | | |
| 63735 | 0.6696 | | |
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| 73491 | 177.6276 | | · · · · · · · · · · · · · · · · · · · |

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| DATE | STEP | PRO | OCEDURE CHA | ANGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| DATE | STEP | Description of NC | 1 . 141 . 1 | Corrective Action Section | on B Sign & | Verification | Approval | Approval QC Inspector |
| | J | Section A | Initial Chief Eng | Action Description Chief Eng | Date | Section C | Chief Eng | |
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Page 2

December-21-11 9:29:28 AM

Work Order ID: 77769 *77769* Parent Item: D350-748-101 *D350-748-101* Parent Item Name: Crosstube Installation, High Fwd Start Date: 21/12/2011 **Required Date: 13/01/2012** Start Qty: 1.00 Required Qty: 1.00 D3502-1 Manufactured No 200 Each 23.0000 2 *D3502-1* ** Support Location Loc Qty Loc Code ST063 23 72129 3 73419 20 MS21920-20 Purchased No 200 Each 60.0000 *MS21920-20* ** Clamp (per MIL-DTL-8783C) Location Loc Qty Loc Code LG050 60 116799 10 119386 50 MS27039-1-10 Purchased No 200 Each 41.0000 *MS27039-1-10* ** Screw Location Loc Qty Loc Code ST291 41 119307 3 119531 38

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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DQ | A: | Date: | |
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| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NC | R) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | 0 1 - | cation | Approval | Approval |
| | J.L. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | | | | QC Inspector |
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Picklist Print Page 3 December-21-11 9:29:28 AM Work Order ID: 77769 *77769* Parent Item: D350-748-101 *D350-748-101* Parent Item Name: Crosstube Installation, High Fwd Start Date: 21/12/2011 **Required Date:** 13/01/2012 Start Qty: 1.00 Required Qty: 1.00 AN4-41A Purchased No 220 Each 285.0000 8 *AN4-41A* ** Location Loc Oty Loc Code ST360 285 115108 3 115705 7 117619 50 117795 25 118451 50 118838 50 119328 100 AN4-6A Purchased No 220 Each 4,130.000 16 16 *AN4-6A* ** Location Loc Qty Loc Code ST356 4130 119017 4130 AN5-32A Purchased No 220 Each 231.0000 *AN5-32A* ** Bolt Location Loc Qty Loc Code ST339 231 118422 6 118628 50 118983 25 119328 100 119862 50

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| Part No | | PAR #: solution: | | | | | | | |
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| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Section Action Description Chief Eng | on B Sign Date | & Sect | cation ion C | Approval Chief Eng | Approval QC Inspector |
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· Picklist Print

December-21-11 9:29:28 AM

Page 4

| Work Order ID: 77769 | | *7 | 7769* | | | | | | |
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| Parent Item: D350-748-101 | | |)350-748-1 | l Λ1 * | | | | | |
| Parent Item Name: Crosstube Installat | ion, High Fwd | • | 7. 1. 1(1- 1 4 ()- | 1 (/ 1 | | S | tart Date: 2 | 1/12/2011 | Required Date: 13/01/2012 |
| | | | | | | 5 | Start Qty: 1 | .00 | Required Qty: 1.00 |
| AN960JD516 NAS1149D0563. | J Purchased | No | | 220 | Each | 0.0000 | 8 | 8 | , |
| *AN960.ID516* | | | | | | | ** | | |
| D3500-1 | Manufactured | No | | 220 | Each | 4.0000 | 4 | 4 | |
| *D3500-1* | | | | | | | ** | | |
| | | | Location | <u>La</u> | oc Qty | Loc Code | | | |
| | | | ST424 | | 4 | | | | |
| D3501-1 | | | 70695 | | 4 | | | | _ |
| | Manufactured | No | | 220 | Each | 396.0000 | | 16 | |
| *D3501-1* Bushing | | | | | | | ** | | |
| | | | Location | <u>Lo</u> | e Oty | Loc Code | | | |
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| | | | 74866 | | 207 | | | | _ |
| MS21042L4 | Purchased | No | | 220 | Each | 9,077.000 | 24 | 24 | _ |
| *MS21042I 4* | | | | | | | ** | | |
| | | | <u>Location</u> | <u>Lo</u> | c Oty | Loc Code | | | |
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| DATE | STEP | Description of NC | | | ection B | 2: | Verific | ation | Approval | Approval |
| DAIL | SIEP | Section A | Initial Chief Eng | Action Description Chief Eng | n ; | Sign & Date | Section C | | Chief Eng | QC Inspector |
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Picklist Print

December-21-11 9:29:28 AM

Work Order ID: 77769

Parent Item:

MS21042L5

D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

77769

D350-748-101

Start Date: 21/12/2011

Required Date: 13/01/2012

Page 5

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

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| Location | Loc Qty | Loc Code |
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| ST300 | 2130 | |
| 116105 | 5 | |
| 116548 | 43 | |
| 117611 | 52 | |
| 118179 | 496 | |
| 118910 | 34 | |
| 119109 | 1500 | |

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| | R | esolution: | Disposit | ion: | QA: N/C | Clos | ed: | | Date: _ | |
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| DATE | STEP | Description of NC | | | tion B | ın & | Verifica | | Approval | Approval |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | 1 7 | ate | Sectio | n C | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 77769 |
|---|--------------|--------------|
| Description: Crosstube High Fwd (AS350/355) | Part Number: | D350-748-101 |
| Inspection Dwg: D350-748-141 Rev: F | | Page 1 of 1 |

| | Required Dimension | Min | Max | 7 |
|--------|--------------------|-------|----------------|-----------|
| | Height | 23.13 | 23.37 | |
| | 1/2 Span | 40.78 | 41.02 | <u>.</u> |
| | Angle | 75 | 77 | |
| | Total Span | 81.56 | 82.04 | |
| | 176 4.472 | | 199 - 4.45 | 5 |
| | 3.7% | ! | 4.4% | |
| 1 | | | | |
| | 7.324 | | 2,327 2,128 | |
| | 2.324 | | 2.128 | 111 |
| 23.630 | | | | 23. 250 Y |
| 1 111 | te. – | | - | 76.5 |
| | 45. | | | |

| Comments | | | | | | | | |
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| Sine | AZ | 3.9 % | crushy | @44 P | suses | | | |
| sine | 13 2 | 2 4.4% | crush | @ 41 | راودو/ | | | |
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| QC15 Inspection | |
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| Date | |

| Rev | Date | Change | Revised by Approved |
|-----|----------|-----------------|---------------------|
| A | 07.02.06 | New Issue | KJ/JM |
| В | 10.08.23 | Dwg Rev updated | KJ 1 |
| С | 11.11.07 | Dwg Rev updated | KJ SON M |

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| W/O: | | | WC | ORK ORDER CHANGES |) | TURNET OF THE PERSON OF THE PE | 7-7-7-7-7-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1 | |
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspecto |
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| Part No | | PAR #: | | | | | | |
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| NCR: | | | WORK ORDI | ER NON-CONFORMAN | CE (NCR | (1) | | |
| | T | Description of NC | | Corrective Action Section B | | Verification | Approval | Approva |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspecto |
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Part Number Description item Qty -141 D350-748-141 X CROSSTUBE ASSEMBLY (AS 350/355 HI FWD) D6015-125 CROSSTUBE (OR D6017-115) 2 D3502-1 SUPPORT 4 D2856-400-710 ABRASION STRIP AELS-1032-225 INSERT NAS1149D0363J WASHER (OR AN960JD10) CLAMP (PER DART SPEC. M-MS21920-20) 2 MS21920-20 MS27039-1-10 SCREW

GENERAL NOTES:

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С

1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115 FINISHED LENGTH = 110.270±0.06

2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2

CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNITS: INCHES UNLESS OTHERWISE NOTED.

BREAK SHARP EDGES: 0.005 TO 0.010 MAX. IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF

PER DART QSI 044 6.4 (VIBRATING STYLUS) WEIGHT: 30,45 lbs

PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.

BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.

NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO

BENDING IS 6% BASED ON O.D.

11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTHBY HARDNESS TEST PER ASTM E18 TO 40-45 HRC. 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,

CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.

13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, ORDENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO

CRACKING/CHIPPING/GROOVES. 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT

NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY RETURN TO ENGINFERMO UNCONTROLL ED COPY SUBJECT TO AMI NUMENT WITHOUT NOTICE WORK ORDER MLJ

11/12/21

UNDER REVIEW



| DESIGN | DADT AFROOD | | T |
|--------|---|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| Α | NEW ISSUE | CP | 06.03.31 |
| 8 | ADD D6017-115 & PRIME AND PAINT | CP | 06.06.30 |
| С | ADD CAD PLATING | CP | 06.08.14 |
| D | MAG. PARTICLE AND CAD PLATE AS MFD. | CP | 06.10.31 |
| E | REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3) | RF | 09.09.30 |
| F | ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4) | СР | 10.11.23 |

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| DRAWN | 97 | HAWKESBURY, ONTARIO, CANADA | | | | |
| CHECKED | <u></u> | DRAWING NO. | REV. F | | | |
| MFG. APPR. | E | D350-748-141 | SHEET 1 OF 4 | | | |
| APPROVED | 1 | TITLE | SCALE | | | |
| DE APPR. | # | CROSSTUBE (AS 350/355 HI FV | VD) NTS | | | |
| DATE 40.4 | 4.00 | COPYRIGHT © 2006 BY DART AEROSPACE LTD | | | | |

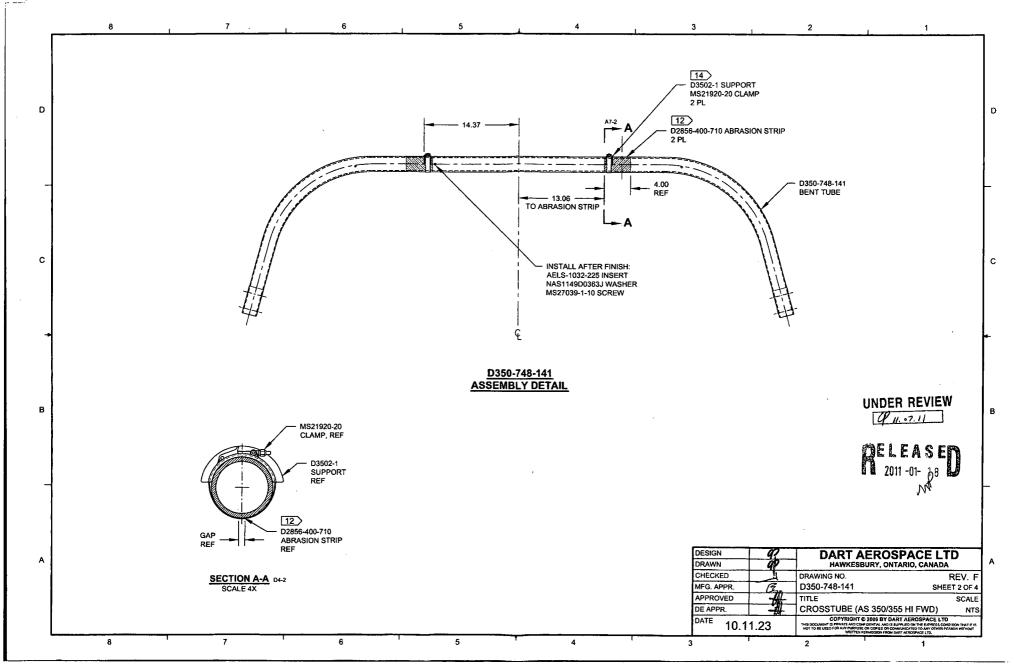
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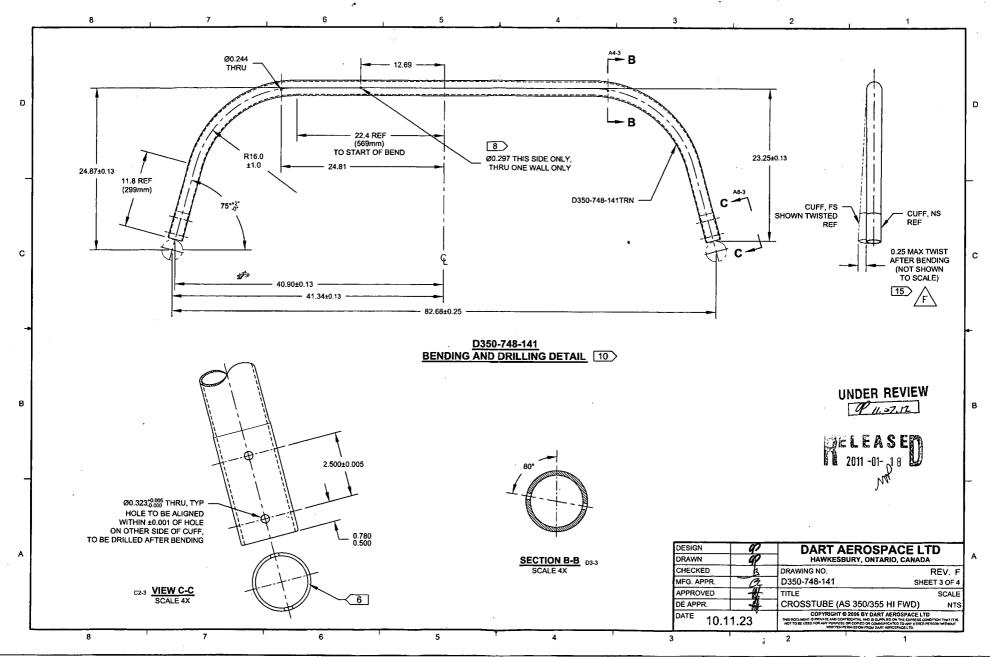
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| DATE | STEP | Description of NC | | | | Verifi | cation | Approval | Approval |
| | J.E. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | | ion °C | Chief Eng | QC Inspector |
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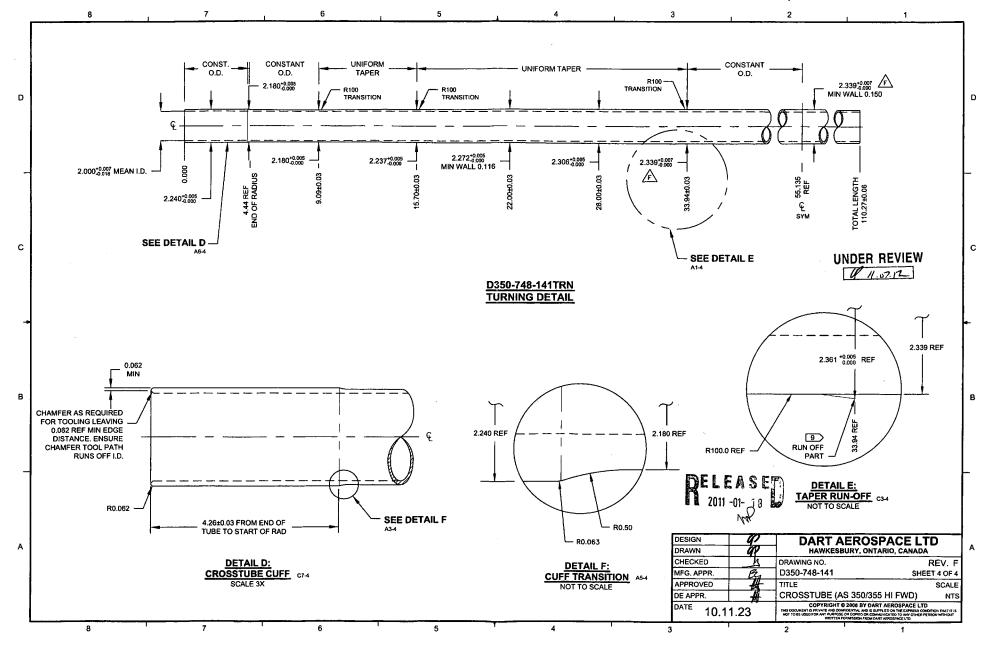


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| Resolution: | | | | | | QA: N/C Closed: Date: | | | | | · |
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| | 0.2 | Section A | Chief Eng | ACI | ion Description Chief Eng | * | Date | | on C | Chief Eng | QC Inspector |
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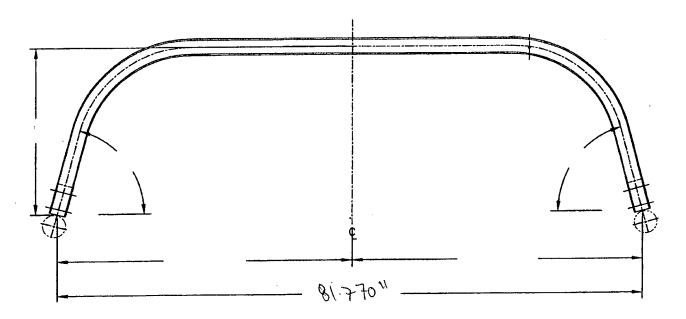


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| Part No: | | PAR #: | Fault Categ | ory: | _ NC | R: Yes | No DQ | A: | | | | |
| | Re | esolution: | Disposition | : | _ QA | : N/C C | losed: | | Date: _ | | | |
| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
| DATE | STEP | Description of NC | | | | ction B Verific | | | Approval | Approval | | |
| - DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign of Date | | on C | Chief Eng | QC Inspector | | |
| | | | | | | | | | | | | |
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| DART AEROSPACE LTD | Work Order: | 77769 |
|---|--------------|--------------|
| Description: Crosstube High Fwd (AS350/355) | Part Number: | D350-748-101 |
| Inspection Dwg: D350-748-141 Rev: F | | Page 1 of 1 |

| FOR stress | Reily) | |
|--------------------|--------|-------|
| Required Dimension | Min | Max |
| Height | 23.13 | 23.37 |
| 1/2 Span | 40.78 | 41.02 |
| Angle | 75 | 77 |
| Total Span | 81.56 | 82.04 |



| Com | ımen <u>ts</u> | | |
|--------|----------------|--------|-------|
| 0.315" | | | |
| | | | |
| | | | |
| - | 0.3/5" | 0.3/5" | O·3/5 |

| QC15 Inspection | |
|-----------------|--|
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|--------------|
| A | 07.02.06 | New Issue | KJ/JM | |
| В | 10.08.23 | Dwg Rev updated | KJ 1() | 14 |
| С | 11.11.07 | Dwg Rev updated | KJ OK | ⊥ <i>X</i> 0 |
| | | | U | • |



CADORATH GROUP NON CONFORMANCE REPORT

| CADORATH AEROSPACE CADORA | ATH DISTRIBUTION |
|---|----------------------------------|
| CADORATH COATING | UNIFLYTE |
| NOTE: THIS FORM MUST BE COMPLETED BY: CUSTOMER VENDOR | BEFORE PROCESSING OF PART(S) |
| | NCR#: C1115 |
| CUSTOMER: Dart Aerospace Ltd. | DATE: 02/24/12 |
| VENDOR: N/A | CADORATH/UNIFLYTE P/O #: |
| PART DESCRIPTION: Skid (Crosstube) | N/A |
| CUSTOMER P/O #: PO 15990 | CADORATH/UNIFLYTE W/O #: |
| | 111679/80/81/82/86 |
| PART #: D350-748-101 | |
| SERIAL #: | QUANTITY: Five (5) |
| PURCHASE ORDER INSTRUCTIONS: MPI and Cad Plate | |
| DISCREPANCY: These parts failed our MPI test after plating. The were shipped back to your facility as of February 24, 2012. | ey all have cracks. The parts |
| Nick Wasylik (QA Manager) N. CADORATH/UNIFLYTH INSPECTION DEPARTM | W. CI 02/29/12 |
| CUSTOMER: PLEASE COMPLETE THIS PORTION, SIGN AND RETURN TOP COPY O VENDOR: | F THIS FORM TO CADORATH/UNIFLYTE |
| DATE: 02/24/12 P/O: PO 15990 | |
| CUSTOMER INSTRUCTIONS: VENDOR CORRECTIVE ACTION: Since the 5 parts were returned, this NCR is the notification the your evaluation. | nat they were sent back for |
| | |
| | * |
| All I LI PORT LIA CICKIA TITITE | sylik (QA Manager) |

DATE: 10/13/10

FORM: OPS 097 REVISION: 3

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